

12 test 28/02

Dart Aerospace Ltd.

*Date: Friday, 09/01/2009 11:03:40 AM
 User: Julie Dawson

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : MONOPOD ASS'Y |
| Job Number : 44526 | |
| Estimate Number : 13177 | |
| P.O. Number : | Part Number : D3686041 |
| This Issue : 09/01/2009 S.O. No. : | Drawing Number : D3686 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : 38480 | Material : |
| Written By : | Due Date : 26/01/2009 Qty: 4 Um: Each |
| Checked & Approved By : <u>DD 09.01.09</u> | |
| Comment : Est Rev:A new issue 08-02-12 DD verified by:JLM Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|-----------------------|
| 1.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

| | | |
|-----|--------|------|
| 2.0 | D36887 | STUD |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

STUD

batch

B44686

1 x 46055

Eps 09/04/16

| | | |
|-----|--------|--------|
| 3.0 | D36891 | SLEEVE |
|-----|--------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

SLEEVE

batch

B44825

Eps 09/04/16

| | | |
|-----|--------|------|
| 4.0 | D36911 | STUD |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

STUD

batch

B45485

Eps 09/04/16

| | | |
|-----|--------|--------|
| 5.0 | D36921 | SPACER |
|-----|--------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

SPACER

batch

B46053

Eps 09/04/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 09/01/2009 11:03:40 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MONOPOD ASS'Y

Job Number: 44526

Part Number: D3686041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|--------|
| 6.0 | D36923 | SPACER |
|-----|--------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

SPACER

batch

B44728 (12x)

B44690 (4x)

EP09/04/16

| | | |
|-----|--------|-----------------|
| 7.0 | D36931 | Rod End Bearing |
|-----|--------|-----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rod End Bearing

batch

B44828

EP09/04/16

| | | |
|-----|--------|-----------------|
| 8.0 | D36933 | Rod End Bearing |
|-----|--------|-----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rod End Bearing

batch

B45724 (1x)

B36880 (3x)

EP09/04/16

| | | |
|-----|---------|------|
| 9.0 | AN3C10A | Bolt |
|-----|---------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

M105940

EP09/04/16

| | | |
|------|---------|-------|
| 10.0 | AN3C12A | Bolts |
|------|---------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolts

batch

M110155

EP09/04/16

| | | |
|------|----------|-----|
| 11.0 | MS210433 | Nut |
|------|----------|-----|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

batch

M111041

EP09/04/16

| | | |
|------|------------|------|
| 12.0 | NAS509L12C | Nuts |
|------|------------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nuts

batch

M106993

EP09/04/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 09/01/2009 11:03:40 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MONOPOD ASS'Y

Job Number: 44526

Part Number: D3686041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

NAS50912C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Nuts

batch

M106993

09/04/16

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound on thread and assemble as per dwg D3684

FF 09-04-20

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

~~050121~~ (4)

09/04/09 (x4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location:

ST B9 D.

09/04/30 (x4)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

Job Completion



MF 09-04-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

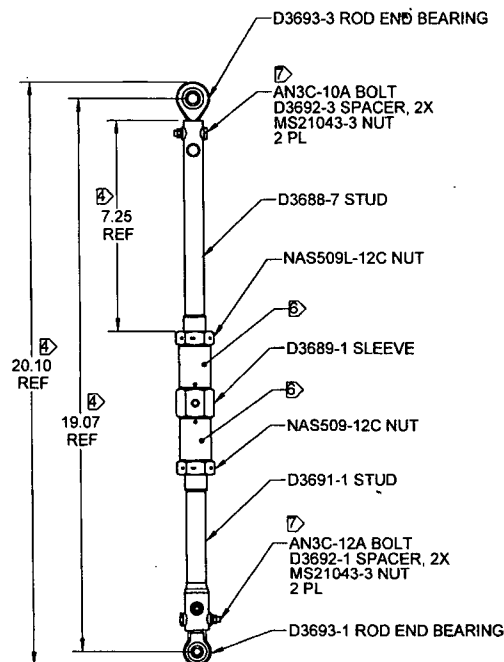
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY -041 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|------------------|
| 1 | X | D3686-041 | MONOPOD ASSEMBLY |
| 2 | 1 | D3688-7 | STUD |
| 3 | 1 | D3689-1 | SLEEVE |
| 4 | 1 | D3691-1 | STUD |
| 5 | 4 | D3692-1 | SPACER |
| 6 | 4 | D3692-3 | SPACER |
| 7 | 1 | D3693-1 | ROD END BEARING |
| 8 | 1 | D3693-3 | ROD END BEARING |
| 9 | 2 | AN3C-10A | BOLT |
| 10 | 2 | AN3C-12A | BOLT |
| 11 | 4 | MS21043-3 | NUT |
| 12 | 1 | NAS509L-12C | NUT |
| 13 | 1 | NAS509-12C | NUT |



D3686-041 MONOPOD ASSEMBLY

RELEASED
08/12/15 JH

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS 1, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs

| | | | |
|------------|--------------------------------------|---|--------------|
| B | REFORMATTED TO CURRENT DWG STANDARDS | RF | 08.11.24 |
| A | NEW ISSUE | RF | 08.05.22 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. | REV. B |
| MFG. APPR. | RF | D3686 | SHEET 1 OF 1 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | MONOPOD ASSEMBLY | NTS |
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